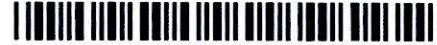




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3649-041
Job Sheet 202474



Part No: D3649-041

Job Qty: 1 pcs

Part Name: Tunnel Bottom Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/29/19

Job Tracking No:

Due Date: 11/27/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A New Issue 07-09-26 EC verified by: DD IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC IPP Rev:C Ecn1162 08-04-02 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	1 pcs		11/27/19	0.17	0.58	Waterjet - Flow		JRB 11/6/19
110	QC 2	1 pcs		11/27/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120	QC 8	1 pcs	11/27/19	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	JRB 11/6/19
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	NIV 0 8 2019
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130	Small Fab - Brake NC - B4B	1 pcs	11/27/19	0.25 0.72	Small Fab - Brake - 1 - B4B	
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
140	QC 5	1 pcs	11/27/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
150	Small Fab - 2 - B4B	1 pcs	11/27/19	0.00 1.09	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	

160 QC 5	1 pcs	11/27/19	0.00 0.00	Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
170 Packaging 3-1 - Stock - B4B	1 pcs	11/27/19	0.00 0.00	QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	

GA-TBD

DAS
21
9-89

OCT 15 2020

180 QC 21 - SA	1 pcs	11/27/19	0.00 0.00	Packaging 3 - 36 - B4B	246 21 88	OCT 15 2020
Part Op 100 - 1-Cut as per Dwg D3649 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - (Bend/Assemble as per dwg) Form as per Dwg D3649 140 - QC5- Inspect part completeness to step on W/O 150 - 1- Form dimple for MS20427M3 rivet per dwg D3649 *****ensure dimples are on the proper side***** 2- Assemble nutplates as per dwg D3649 160 - QC5- Inspect part completeness to step on W/O 170 - Identify as per dwg & Stock Location: _____ 180 - QC21- Final Inspection - Work Order Release						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M304S26GA	304/316 0.018 Sheet	6.0690 sf (6.069 ea)	100-Waterjet - Flow - 1	8155268		
MS20427M3-3	Rivet	88 Ea (88 ea)	150-Small Fab - 2 - B4B			
MS21060-3K	Nut Plate	22 Ea (22 ea)	150-Small Fab - 2 - B4B			
MS21062-3K	Nut Plate	22 Ea (22 ea)	150-Small Fab - 2 - B4B			
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Waterjet - Flow - 1	M304S26GA	6	170	0		
150-Small Fab - 2 - B4B	MS20427M3-3	88	2,151	0		
	MS21060-3K	22	166	0		
	MS21062-3K	22	155	0		
Part Specifications						
Specifications could not be found.						

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Container No: S229518



Part: D3649 - 041

Job No: 202474

Serial No/Batch: S229518

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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 TEL.: 1 813 632-5200
 Email: sales@dartaero.ca
 www.dartaerospace.com

Date: 11/06/19

DART AEROSPACE LTD		Work Order: 202474
Description: Tunnel Bottom Panel		Part Number: D3649-1
Inspection Dwg: D3649	Rev: B	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.100	✓		JRB-02V	
Ø0.196	+0.005/-0.001	0.195	✓		JRB-01V	
Ø0.250	+0.005/-0.001	0.249	✓		Type	
0.400	+/-0.010	0.404	✓			
0.385	+/-0.010	0.388	✓			
0.250	+/-0.010	0.256	✓			
44.57	+/-0.030	44.58	✓			
11.70	+/-0.030	11.72	✓			
3.370	+/-0.030	3.374	✓			
13.76	+/-0.030	13.78	✓			
4.300	+/-0.010	4.300	✓			
10.11	+/-0.030	10.11	✓			
12.90	+/-0.030	12.92	✓			
16.61	+/-0.030	16.58	✓			
15.80	+/-0.030	15.75	✓			
3.950	+/-0.010	3.950 3.948	✓			
0.42	+/-0.030	0.43	✓			
0.41	+/-0.030	0.40	✓			
0.85	+/-0.030	0.85	✓			
19.64	+/-0.030	19.66	✓			
0.54	+/-0.030	0.50	✓			
1.400	+/-0.010	1.400 1.399	✓			
2.63	+/-0.030	2.65				
2.93	+/-0.030	2.97				
1.49	+/-0.030	1.50				
5.98	+/-0.030	5.99				
0.54	+/-0.030	0.54				
2.20	+/-0.030	2.20				
2.75	+/-0.030	2.76				
2.48	+/-0.030	2.50				

DART AEROSPACE LTD		Work Order:	
Description: Tunnel Bottom Panel		Part Number:	D3649-1
Inspection Dwg: D3649 Rev: B		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.16	+/-0.030	1.16	/			
3.38	+/-0.030	3.40				
2.00	+/-0.030	2.07				
0.90	+/-0.030	0.92				
16.64	+/-0.030	16.60				
0.48	+/-0.030	0.48				
13.80	+/-0.030	13.82				
0.46	+/-0.030	0.47				
11.76	+/-0.030	11.77				
1.23	+/-0.030	1.25				
0.88	+/-0.030	0.88				
18.46	+/-0.030	18.46				
5.23	+/-0.030	5.28				
1.932	+/-0.010	1.930				
1.943	+/-0.010	1.941				
5.02	+/-0.030	5.00				
1.820	+/-0.010	1.820				
0.70	+/-0.030	0.70				
2.100	+/-0.010	2.101				
2.33	+/-0.030	2.36				
0.94	+/-0.030	0.95				
3.30	+/-0.030	3.32				
1.900	+/-0.010	1.901				
0.61	+/-0.030	0.61				

Measured by: JRB Date: 11/6/19	Audited by: DAS 40 Date: NOV 08 2019	Prototype Approval: N/A Date: N/A
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Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	P/O D3649-041 KJ/DD	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details: _____			